

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020266**Date Inspected:** 28-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC)**Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Inspected CWI report:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
		<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Trial Assembly	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Suspender Brackets (Faying Surface Gap Measurements)

This Quality Assurance (QA) Inspector measured the flatness across the Suspender Bracket Face which will come in contact with Edge Panel. Inspection was performed at the pre-installation stage. The result of Inspection was informed to ZPMC CWI Mr. Shaji and QA Mr. Zhang Wei. Inspection was performed at Bay # 19.

The following Suspender Brackets were inspected.

SB106E for the Segment 11DE.

SB106W for the Segment 11DW.

SB108W for the Segment 11EW

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The Flatness measurements, measured was informed to Lead Inspector Mr. Mark. J. Miller and Mr. Hiranch Patel.

Please reference the pictures attached for more comprehensive details.

### Segment 14AE ( Segment Assembly)

This QA Inspector performed Dimension Control Inspection for the Hinge Pipe Stiffeners distance, distance was measured within the 25mm from fillet weld for the Segment 14AE at Panel Point (PP) 127 at the following locations at Bay # 14:

#### North Side (Cross Beam side)

Measured the Elevation of Stiffeners at 967mm.

Measured the Elevation of Stiffeners at 2292mm.

Measured the Elevation of Stiffeners at 3042mm.

Measured the Elevation of Stiffeners at 4042mm.

Measured the Elevation of Stiffeners at 4828mm.

#### South Side (Bike Path side)

Measured the Elevation of Stiffeners at 967mm.

Measured the Elevation of Stiffeners at 2292mm.

Measured the Elevation of Stiffeners at 3042mm.

Measured the Elevation of Stiffeners at 4042mm.

Measured the Elevation of Stiffeners at 4828mm.

The QA Inspector measured the Mis-Alignment using 600mm Straight Edge, Carpenter Square and Measuring Tape.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

### Segment 14AE ( Segment Assembly)

This QA Inspector performed Dimension Control Inspection for the Hinge Pipe Stiffeners distance, distance was measured within the 25mm from fillet weld for the Segment 14AE at Panel Point (PP) 127.3 at the following

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locations at Bay # 14:

North Side (Cross Beam side)

Measured the Elevation of Stiffeners at 967mm.

Measured the Elevation of Stiffeners at 2292mm.

Measured the Elevation of Stiffeners at 3042mm.

Measured the Elevation of Stiffeners at 4042mm.

Measured the Elevation of Stiffeners at 4828mm.

South Side (Bike Path side)

Measured the Elevation of Stiffeners at 967mm.

Measured the Elevation of Stiffeners at 2292mm.

Measured the Elevation of Stiffeners at 3042mm.

Measured the Elevation of Stiffeners at 4042mm.

Measured the Elevation of Stiffeners at 4828mm.

The QA Inspector measured the Mis-Alignment using 600mm Straight Edge, Carpenter Square and Measuring Tape.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

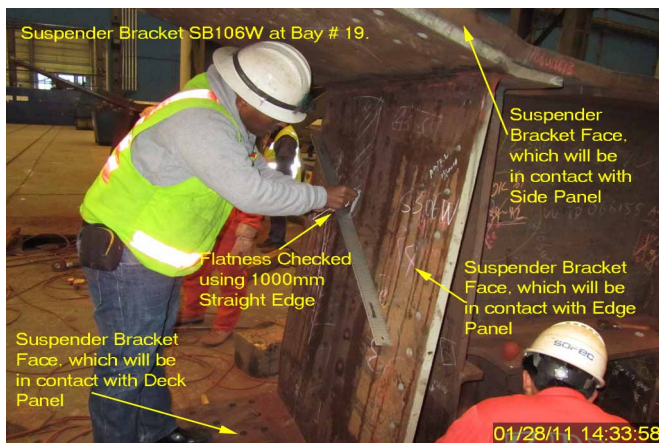
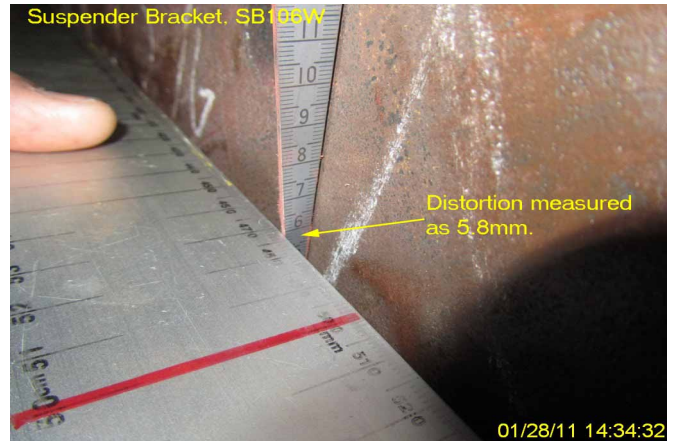
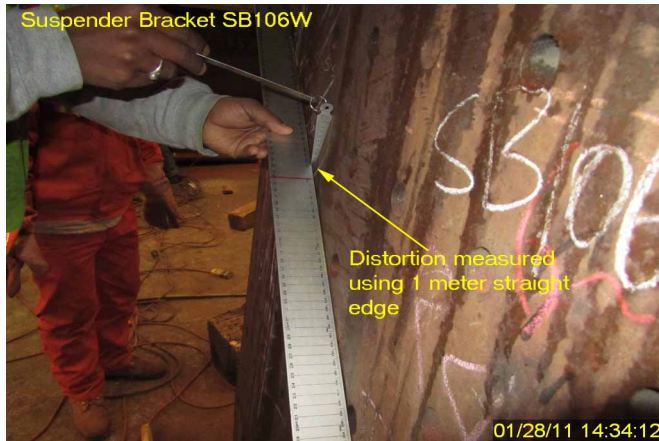
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## Summary of Conversations:

No relevant conversations were reported on this date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Math,Manjunath

Quality Assurance Inspector

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**Reviewed By:** Dsouza,Christopher

QA Reviewer

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